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27/Dec

20

D4776-1
Job Sheet 186698



Part No: D4776-1

Job Qty: 10 ea

Part Name: Basket Strut Clevis



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/20/18

Job Tracking No:

Due Date: 12/7/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV D SHEET 1 IPP REV:A 13.02.28 NEW ISSUE DD VERF:JFS IPP REV:B 13.09.26 AS PER REV.B DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		12/7/18	0.00	0.00	Start Up Machining-3		
100	Doosan	10 pcs		12/7/18	0.54	5.32	Doosan		
105	QC	10 pcs		12/7/18	0.00	0.00	QC2 Machining-3		
111	QC	10 pcs		12/7/18	0.00	0.00	QC8 Machining-3		
112	HandFinish	10 pcs		12/7/18	0.00	0.29	HandFinish1		
113	QC	10 pcs		12/7/18	0.00	0.00	QC7-4		
115	Powdercoat	10 pcs		12/7/18	0.00	0.12	Powdercoat1		
116	QC	10 pcs		12/7/18	0.00	0.00	QC3		
130	Packaging	10 pcs		12/7/18	0.00	0.00	Packaging3-2		
140	QC21-SA	10 Ea		12/7/18	0.00	0.00	QC21		

Part Op 100 - 1- Turn as per Folio FB167 Dwg D4776 Rev: 2
Descriptions: 115 - MASK .403 ROUND SECTION AS PER DWG

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6R1.500	6061-T6 Round Bar 1.50	2.9000 ft (.29 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6R1.500	3	18	0

M138951 START: 3:15 PM TEMP: 320° FINISH: 3:45 PM

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Basket Strut Clevis	0.880Inches ± 0.030	0.910 0.850	.88	
2	Basket Strut Clevis	0.438Inches ± 0.010	0.448 0.428		
3	Basket Strut Clevis	0.380Inches ± 0.030	0.410 0.350		
4	Basket Strut Clevis	0.625Inches ± 0.010	0.635 0.615		

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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OTHER : _____																																																																					

5	Basket Strut Clevis	1.750Inches ± 0.030	1.780 1.720	
6	Basket Strut Clevis	3.500Inches ± 0.030	3.530 3.470	
7	Basket Strut Clevis	45.000Degrees ± 0.500	45.500 44.500	Angle
8	Basket Strut Clevis	0.030Inches ± 0.030	0.060 0.000	
9	Basket Strut Clevis	0.060Inches ± 0.030	0.090 0.030	Radius
10	Basket Strut Clevis	0.196Inches + 0.006 - 0.001	0.202 0.195	Diameter
11	Basket Strut Clevis	0.261Inches + 0.006 - 0.001	0.267 0.260	Diameter
12	Basket Strut Clevis	0.410Inches ± 0.030	0.440 0.380	Radius
13	Basket Strut Clevis	1.130Inches ± 0.030	1.160 1.100	
14	Basket Strut Clevis	0.188Inches ± 0.010	0.198 0.178	
15	Basket Strut Clevis	0.190Inches ± 0.030	0.220 0.160	
16	Basket Strut Clevis	0.500Inches ± 0.030	0.530 0.470	
17	Basket Strut Clevis	0.750Inches ± 0.010	0.760 0.740	
18	Basket Strut Clevis	0.403Inches + 0.000 - 0.005	0.403 0.398	Diameter
19	Basket Strut Clevis	0.130Inches ± 0.030	0.160 0.100	Radius
20	Basket Strut Clevis	0.750Inches + 0.010 - 0.000	0.760 0.750	
21	Basket Strut Clevis	0.160Inches ± 0.030	0.190 0.130	
22	Basket Strut Clevis	45.000Degrees ± 0.500	45.500 44.500	Angle

Plex 11/20/18 11:30 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____ Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS					
	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐			

Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
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Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

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CANADA
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Email: sales@dartaero.com
www.dartaerospace.com



Container No: S136799



Part: D4776 - 1

Job No: 186698

Serial No/Batch: S136799

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 12/11/18

FAULT CATEGORY

☐	Power Loss/Surge	☐	Positioned Wrong
☐	Folio/Program	☐	Outside Dimensions
☐	Grain	☐	Over/Under tolerance
☐	Weld	☐	Part Incorrect
☐	Wrong Stock Pulled	☐	Part Lost/Missing
☐	Out of Sequence	☐	Part Moved
☐	Off-set	☐	Drawing
☐	Mislabeled	☐	Finish
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